












split while

Dart Aerospace Ltd.

Date: Thursday, 27/11/2008 2:23:32 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT CAP
Job Number : 43801	
Estimate Number : 10312	
P.O. Number :	Part Number : D2646
This Issue : 27/11/2008 S.O. No. :	Drawing Number : D2646 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 41435	Material :
Written By :	Due Date : 10/12/2008
Checked & Approved By : JUD 08.11.27	Qty: 50 Um: Each
Comment : Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM Est Rev: H Changed Inserts 07-02-19 JLM est rev I changed inserts 07.06.11 EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	PG PURCHASING
 	
Comment: PURCHASING Issue P/O: 7706 1-Spin as per Dwg D2646 2-Material release note required C20811/28 (50)	
2.0	D2646P Aft Cap
 	
Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s) AFT CAP	
3.0	PACKAGING 1 PACKAGING RESOURCE #1
 	
Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached R 8/11/11 (50)	
4.0	QC6 DIMENSIONAL CHECK
 	
Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2646 S 02/12/12 counter (50)	
5.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill using DT8026 as per Dwg D2646. E 08/12/12 (50)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:23:33 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 43801

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Open holes to .297 as per Dwg D2646.

3-Deburr

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M 109996

10:30
3200F
11:00

M-L 08/12/19

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

INSERT

Batch: M105819

Q.M 09.01.15 (34)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

Q.M 09.01.15 (34)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/01/15 (34)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:23:33 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 43801

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

Q.m 09-01-15 ~~34~~ (34)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/16 AF

Job Completion



mk 09-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

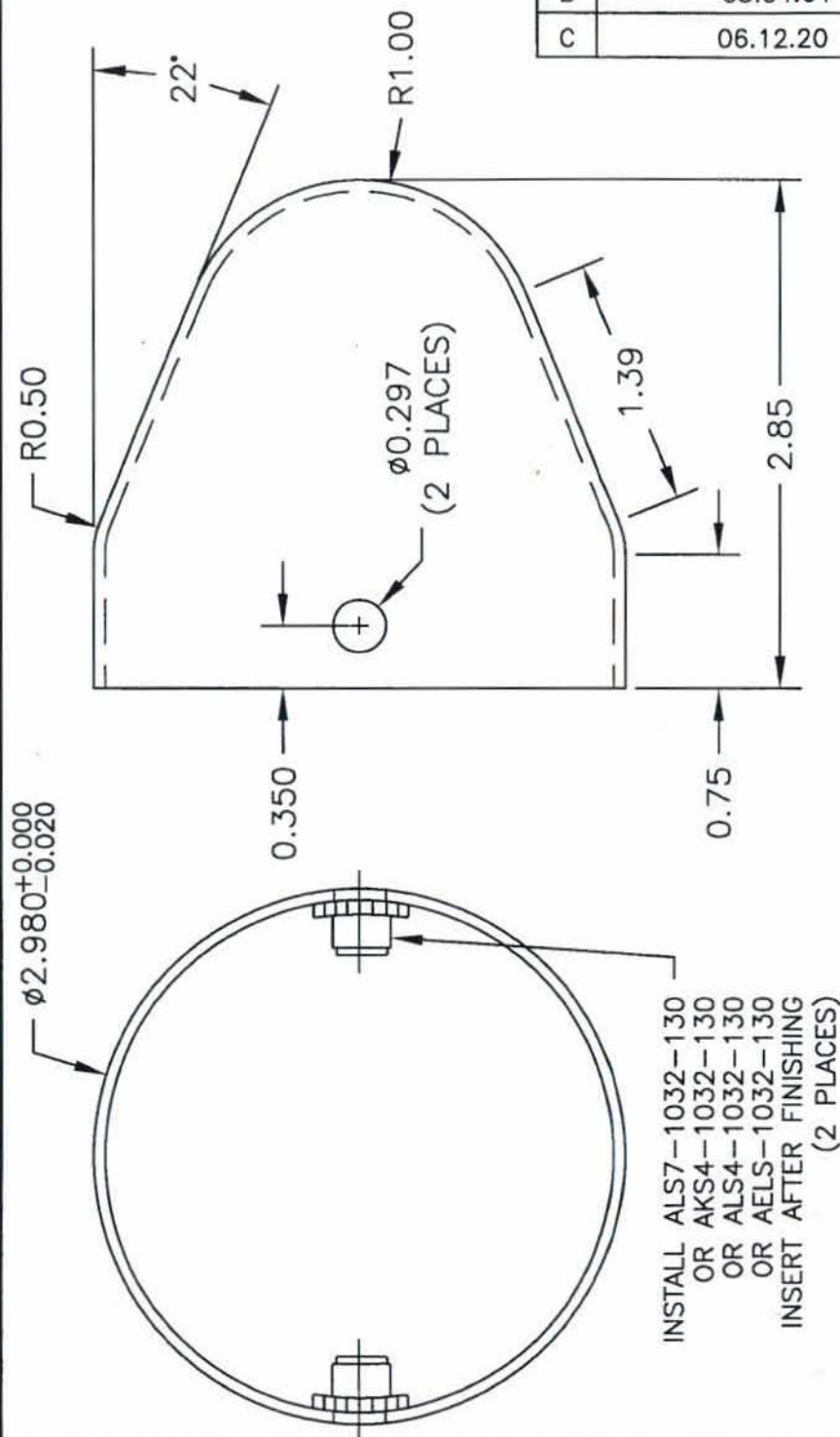
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
				D2646	SHEET 1 OF 1
DATE	06.12.20	TITLE	AFT CAP	SCALE	1:1
A	97.03.25	NEW ISSUE			
B	05.04.01	CHANGE TO CLOSED INSERTS			
C	06.12.20	CHANGE TO OPEN ENDED INSERTS			



RELEASED

07.02.12

- D2646 AFT CAP**
- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43801

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W. H. KERRY



ALCOA VIII PRODUCTS
1480 Manheim Pike
Lancaster Pa 17601

Certification of Test Results

P/N 970200

PO 38C880

SOLD TO

SHIP TO

CERT NO 3000675396
DATE 4/23/2007
SKID NO 661032
SKID WGT 9,885
PAGE 1 OF 1

ORDER NO	LG5947	PO NO	43-62756	MILL FINISH
ITEM NO	1	PART NO		NON ANODIZE QUALITY
ALLOY	1100	TEMPER	O	OUT: STANDARD MILL FINISH
GAUGE	.05300	WIDTH	48.0000	IN: STANDARD MILL FINISH
		LENGTH	0.0000	NOT EMBOSSED

LOT: 334171 COIL: B02 DROP: 07T0187

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
*U718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI
TAIL ULTIMATE STRENGTH 13.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI
HEAD ELONGATION (G.L. = 2 IN) 32 %
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

Handwritten: S 02/12/12

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 C, AMS 4001H 1100 O,

ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O

PAX CERTS: 714-736-4840

** END OF CERTIFICATION **

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

These are modified, facsimile and otherwise prepared from the original issued in accordance with the Export Administration Regulations. Diversion contrary to U.S. law prohibited.

Authorized By:

JEFF KREADY, LAB SUPERVISOR

Sold to: COPPER & BRASS SALES PO: 38C880 Part: Order No.: 376276

TR clerk signature: *C. K. KERRY*



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: 12/10/08

Customer: Dart Aerospace

Packing Slip: 36123

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By:
D26416P	50	140A	n/a	✓	JS

Notes:

PO# 7706

S
02/12/12

Material Certification Attached: Yes